



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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D3272-1

Job Sheet 183620



Part No: D3272-1

Job Qty: 10 ea

Part Name: Step



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 9/21/18

Job Tracking No:

Due Date: 10/26/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV B IPP Rev:A New Issue 07-06-09 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea		10/26/18	0.00	0.00	Start Up Large Fab-4		SLy
100	Large Fab	10 pcs		10/26/18	0.00	4.65	Large Fab 8		SLy DAS
110	QC	10 pcs		10/26/18	0.00	0.00	QC5		OCT 10 2018 68
120	Packaging	10 pcs		10/26/18	0.00	0.00	Packaging3 Large Fab		SLy 9-89
130	QC21-SA	10 Ea		10/26/18	0.00	0.00	QC21		SLy 18/10/12

Part Op 100 - ***SQUARE ONE END BEFORE CUTTING OTHER END*** 1-Cut D2622-120 extrusion to 116.25" long as per Dwg
Descriptions: D3272 using cutting table setup DT 8185-2A 2-Drill extrusion as per Dwg D3272 using Jig DT8680 for rivets. 3-Debur
120 - LOCATION: WA003

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2622-120C	Step Extrusion	10 Ea (1 ea)	90-Start up Operation	9104007

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2622-120C	10	165	0

Part Specifications

Specifications could not be found.



Container No: S116976



Part: D3272-1

Job No: 183620

Serial No/Batch: S116976

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

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CANADA
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Email: sales@dartaero.com
www.dartaerospace.com

Date: 10/10/18

Plex 9/21/18 2:04 PM Dart.lajeunesse.marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION		AGAINST DEPARTMENT/PROCESS			
	Rework ☐	Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	
	Scrap ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	
	Use-as-is ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	
	Suspected Unapproved ☐	Large Fab ☐	Composite ☐	Supplier ☐		

Date : _____	Step #: _____	QTY Effective : _____	MRB (QSI042) Approval
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Description Work Order Deviation	Disposition	Completed By
		Lead hand / Supervisor Approval Verification
		QC / QA Coordinator Approval

Root Cause				FAULT CATEGORY			
Environment ☐	Design ☐	Draw/Date ☐	Equip/Tooling ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Material ☐	Internal Process ☐	Tool Knowledge ☐	QA ☐	Setting ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
Supplier ☐	Training ☐	Use for Integ ☐	Post Expiry Date ☐	Shift/Setup ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
Supplier ☐	Training ☐	Use for Integ ☐	Post Expiry Date ☐	Broken/Damage/Defect ☐	Inspection Incomplete/Unqualified ☐	Weld ☐	Part Incorrect ☐
Supplier ☐	Training ☐	Use for Integ ☐	Post Expiry Date ☐	mp/Kink/Ripple/Wave ☐	Contamination ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
Supplier ☐	Training ☐	Use for Integ ☐	Post Expiry Date ☐	ffs ☐	Countersink ☐	Out of Sequence ☐	Part Moved ☐
Supplier ☐	Training ☐	Use for Integ ☐	Post Expiry Date ☐	ishing ☐	Cut Too Short ☐	Off-set ☐	Drawing ☐
Supplier ☐	Training ☐	Use for Integ ☐	Post Expiry Date ☐	at Treat ☐	Instructions Incomplete/Unclear ☐	Mislabeled ☐	Finish ☐
Supplier ☐	Training ☐	Use for Integ ☐	Post Expiry Date ☐	ive/Twist in Tube ☐	Drill Holes ☐	Fit/Function ☐	Misread ☐
Supplier ☐	Training ☐	Use for Integ ☐	Post Expiry Date ☐	orks/Chatter ☐		Misaligned/off center ☐	Turning Sequence ☐

Misidentified ☐	Past Due ☐	OTHER : _____
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DART

DESIGN <i>GP</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>H</i>	DRAWING NO. D3272	REV. B SHEET 1 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE NTS
A	04.03.01	NEW ISSUE	
B	07.05.18	D3272-1 WAS D2622-120	

RELEASED07.06.04 *H*

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D3272-041	STEP ASSEMBLY, HIGH LONG (LH)
	X	D3272-042	STEP ASSEMBLY, HIGH LONG (RH)
1	1	D3065-041	LEG ASSEMBLY
2	2	D3066-1	SPACER
2	2	D3067-1	END PLATE
2	2	D3219-1	SUPPORT
1	1	D3272-1	STEP
16	16	MS20600AD4W4	RIVET

GENERAL NOTES:

- 1) D3272-041 SHOWN. FOR D3272-042, INSTALL D3219-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED.
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX.

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WORK ORDER

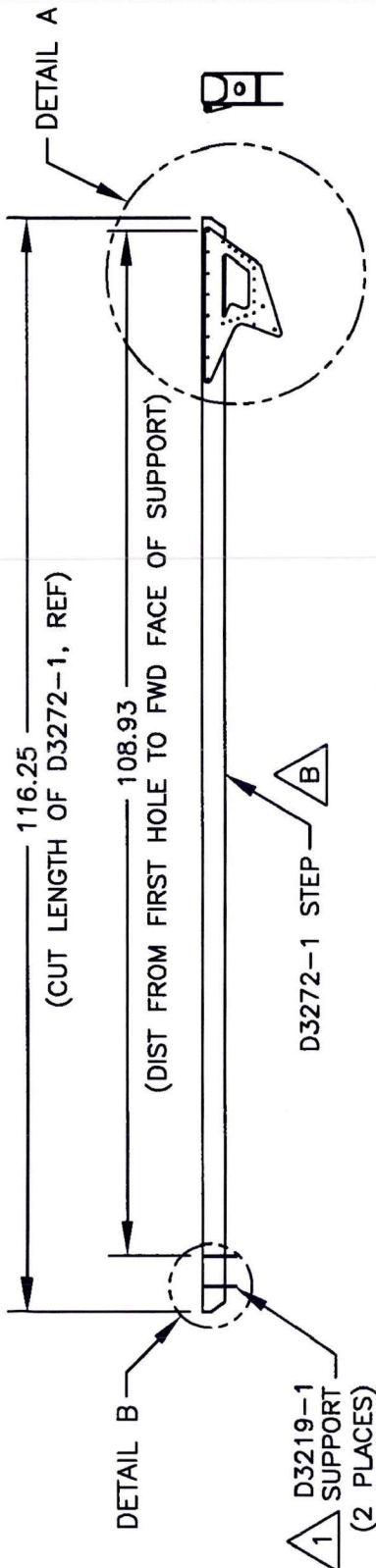
NO. *183620 MJS*
18-09-21

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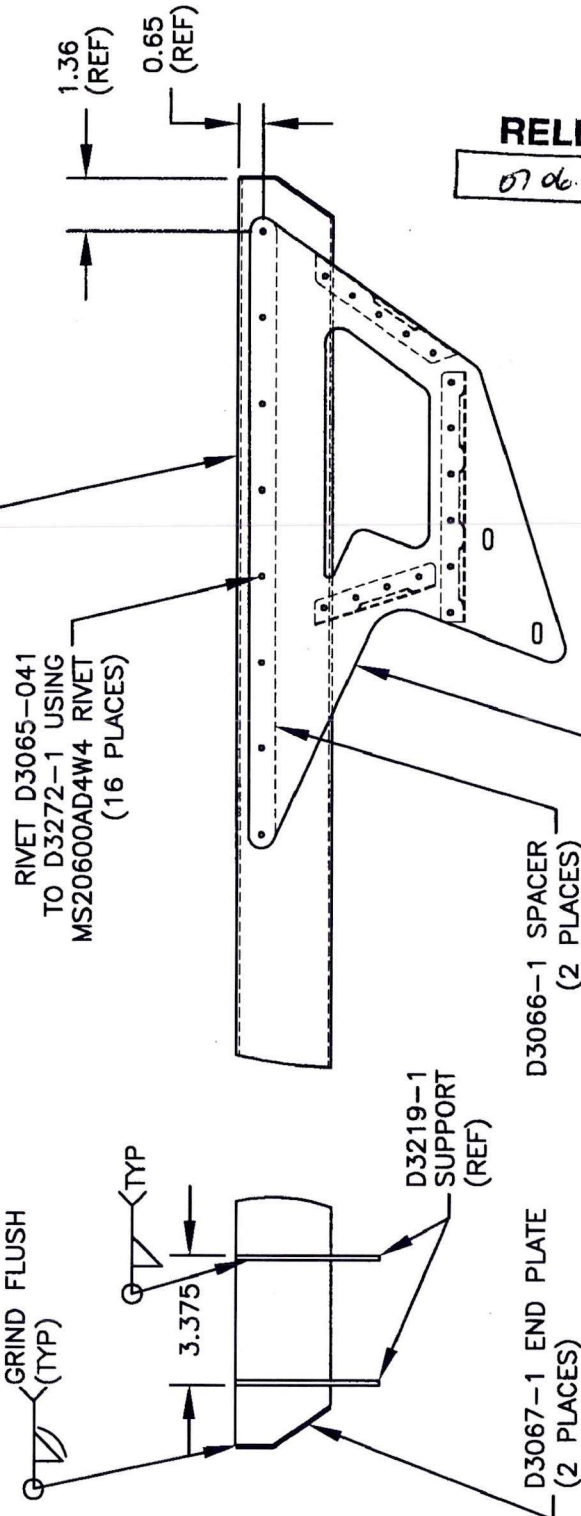
DART

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CHECKED LE	APPROVED [Signature]	DRAWING NO. D3272	REV. B SHEET 2 OF 3
DATE 07.05.18	TITLE STEP ASSEMBLY, HI LONG		SCALE 1:20



D3272-041 STEP ASSEMBLY (LH. SHOWN)
D3272-042 STEP ASSEMBLY (RH, OPPOSITE)

APPLY BLACK ANTI-SKID
ON TOP SURFACE TO
BOTTOM OF TOP RADIUS

**RELEASED**

07.06.04 [Signature]

DETAIL A
(SCALE 1:5)

DETAIL B
(SCALE 1:5)

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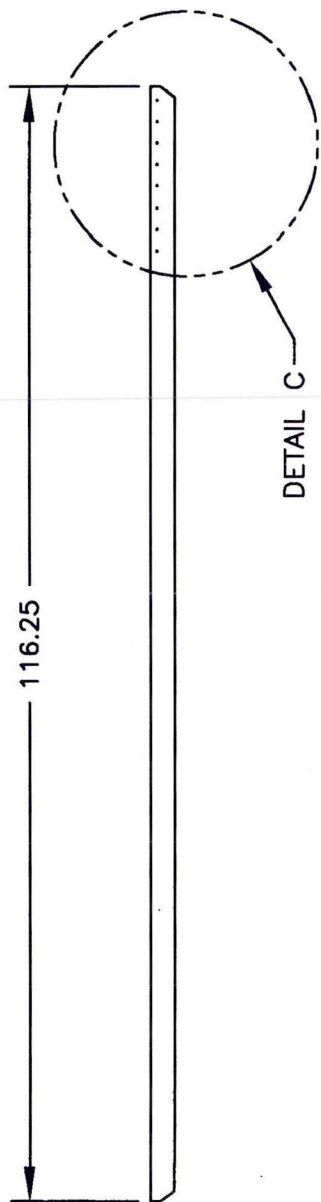
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CHECKED <i>LE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3272	REV. B SHEET 3 OF 3
DATE 07.05.18	TITLE STEP ASSEMBLY, HI LONG		SCALE 1:20

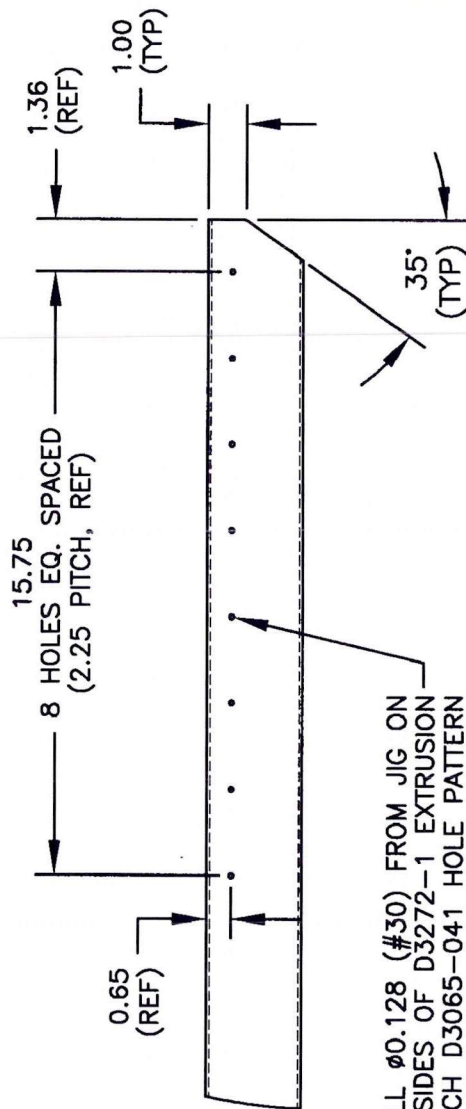
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07.06.04 *[Signature]*



DETAIL C

B D3272-1 STEP
(MAKE FROM D2622-120 STEP EXTRUSION)



DRILL $\phi 0.128$ (#30) FROM JIG ON BOTH SIDES OF D3272-1 EXTRUSION TO MATCH D3065-041 HOLE PATTERN

DETAIL C
(SCALE 1:5)

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